

Work Order ID 53155

October 23, 2009 10:54:16 AM



Page 1

Item ID:	D3983-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Outer Closeout					
Start Date:	23/10/2009	Start Qty:	10.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3983	A								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3983								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

13 9-10-28

(10)






13 9-10-28

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Item ID: D3983-1 Accept  Setup Start 
Revision ID: A Step 
Item Name: Outer Closeout
Start Date: 23/10/2009 Start Qty: 10.00  Cust Item ID:
Required Date: 30/10/2009 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 225 02/10/22 0.00					f		
130  HandFinish Hand Finishing	Chemical Conversion Coatper QSI005 4.1 Memo	0.00 BR 09-10-29 0.00							
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 mp 09/10/29 0.00				X10			

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Item ID: D3983-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Outer Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/09 10257

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02 JF
Pl 09-10-30
(10)

Picklist Print

October 23, 2009 10:54:20 AM

Page 1

Work Order ID: 53155



Parent Item: D3983-1



Parent Item Name: Outer Closeout

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	90.3986	6.4347			
6061-T6 .040 Sheet												



B 910-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

90.3986

100742

3.3

102723

5.93

105842

12

106747

5.7516

107461

11.7841

109396

22.28

111224

27.8529

19380

1.5

113004

113004

DART AEROSPACE LTD		Work Order:	53155
Description: OUTER CLOSET		Part Number:	D3983-1
Inspection Dwg: D3983-1 Rev: A		Page 1 of 1	

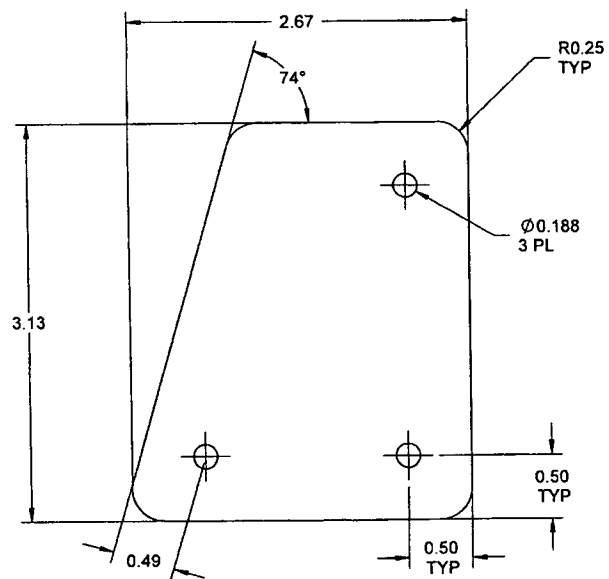
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

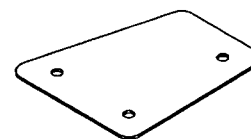
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .006 - .001	.257	✓			
Ø .206	+ .005 - .001	.208	✓			
.44	± .030	.443	✓			
.50	± .030	.503	✓			
1.13	± .030	1.131	✓			
2.19	± .030	2.184	✓			
4.56	± .030	4.563	✓			
4.90	± .030	4.900	✓			
5.50	± .030	5.501	✓			
5.91	± .030	5.908	✓			
6.58	± .030	6.585	✓			
2.84	± .030	2.847	✓			
4.25	± .030	4.237	✓			
6.03	± .030	6.035	✓			
9.59	± .030	9.593	✓			
12.05	± .030	12.045	✓			
12.88	± .030	12.88	✓			
13.38	± .030	13.375	✓			
.040	± .010	.038	✓			

Measured by:	WB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-08	Date:	02/10/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3983-3 INNER CLOSEOUT



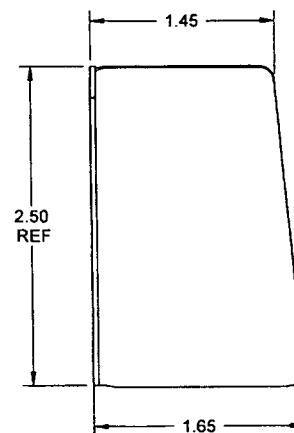
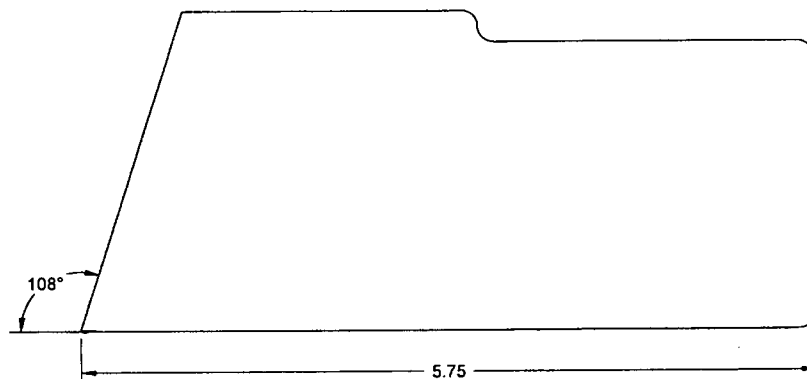
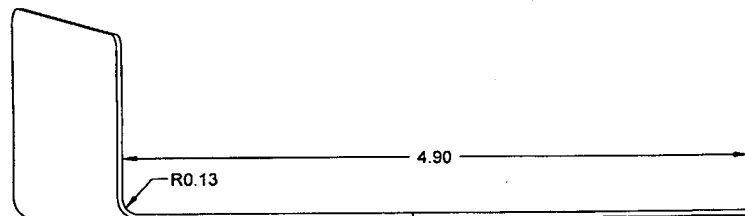
W/0 53155

0.040
REF

RELEASED
2009-10-13
M

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-3" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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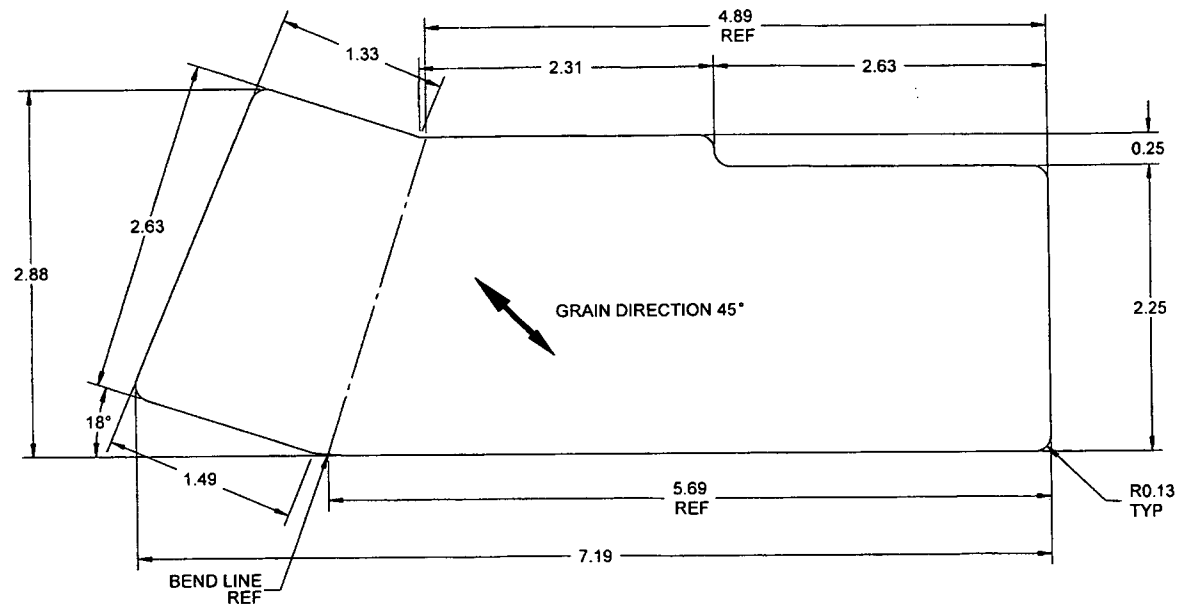
w/ 53155

D3983-5 HINGE CLOSEOUT
(MADE FROM D3983-5F)

RELEASED
2009-10-13

NOTES:
MATERIAL: D3983-5F
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 3 OF 7
APPROVED		TITLE	SCALE
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W/053155

D3983-5F HINGE CLOSEOUT FLAT PATTERN

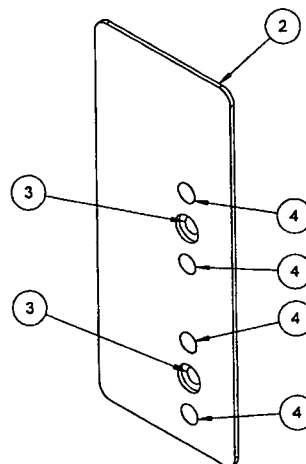
RELEASED
2009-10-13

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040

FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 4 OF 7
APPROVED		TITLE	SCALE
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



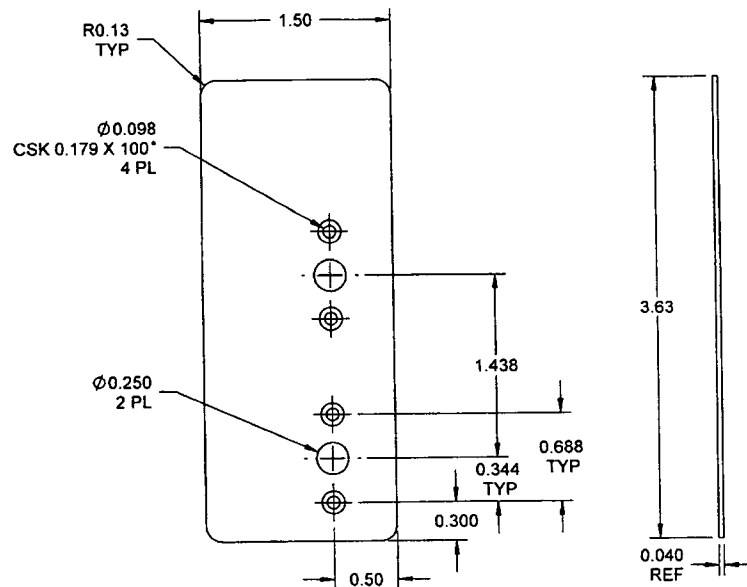
D3983-047 CLOSEOUT ATTACHMENT

W/O 53155

RELEASED
2009-10-13
MD

NOTES:
 MATERIAL: SEE BOM
 FINISH: N/A
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER
 WEIGHT: 0.03 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3983	SHEET 5 OF 7
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	CLOSE OUT KIT	NTS
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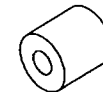
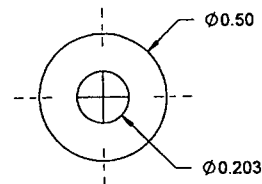
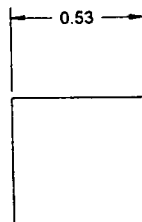
D3983-7 PLATE

W/O 53155

RELEASED
2009-10-13
MD

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.02 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3983	SHEET 6 OF 7
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W/O 53155

D3983-9 SPACER

RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR, ϕ 0.500
PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061TR
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.01 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QJ	DRAWING NO.	REV. A
MFG. APPR.	DS	D3983	SHEET 7 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CLOSE OUT KIT	NTS
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